Work O	rder ID	73	394
Wednesday, .			
r. In	D2527		



Page 1

Wednesday, Aug	ust 31, 2011	3:04:09 PM	`								8-	_
Item ID: Revision ID:	D3537-1	/		Accept				s	etup Sta			
Item Name:	Wearpad								Sto	op		
Start Date:	8/31/2011	Start Qty: 50.0	o (Cust Item	ID:						
Required Date:	9/16/2011	Req'd Qty: 50.00	o		Customer:	:						
Reference:												
Approvals:	Process Plan	n: CL	Date: 11/08/31	Tooling:	Е	Pate:		R	tun Sta			
	QC:	••.	Date:	_ SPC (Y/N):	D	Oate:			St	эр 		
Sequence ID/ Work Center II		Operation Description		- Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revi	ision Nbr							í			
D3537	Rev	С		,	•							
100				0.00								
		FLOW WATER JET						B11-	9-12			_
Waterjet FLOW CNC Waterje	ot	Memo	per Dwg D3537□Dwg Rev:_	0.00	□2-Deburr							
1200 CIVE Walciji 304、063	ot .	if necessa		LIFIOG REV	- d 2-Debuii		•					
										(4)	7)	
110		QC2- Inspect parts off	f machine FAI/FAIB	0.00								
		202 mspeet parts on		0.00				^	C -			
QC		Memo		0.00				1311-	9-17			-
Quality Control												
								chus				
120 Lebber 1981 1981 1881 1881		QC8- Inspect parts - se	econd check	0.00			C					
			•	0.00 کرر	05(13		((760)				_
Quality Control		Memo		0.00	ŕ		,					

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54	•	

W/O:		WORK ORDER C	HANGES	-			
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				······································			
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	\ :	Date: _	

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

TEP	Description of NO						
TEP			Corrective Action Section B	Verification	A1	Annuoval	
Section A	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

Insp.

Stamp

Wednesday, August 31, 2011 3:04:09 PM Item ID: D3537-1 Accept Setup Start **Revision ID:** Stop Item Name: Wearpad **Start Date:** 8/31/2011 **Start Oty: 50.00 Cust Item ID: Required Date: 9/16/2011** Req'd Qty: 50.00 **Customer:** Reference: Start Run Process Plan: Tooling: Date: Approvals: Date: Stop Date: _____ **SPC (Y/N):** Date: Sequence ID/ **Operation** Tool ID Tool # Plan Set Up/ Accept Reject Reject Work Center ID Description Qty **Run Hours** Code Otv Number 130 0.00 NC BRAKE Brake NC Memo S1169/13 Brake NC 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. \[\sigma 2-Identify as D3537-1 ×60 11-09-16 BC 0.00 140 Large Fab 0.00 Large Fab Memo Batch $\square A/R$ Large Fab Description 2059B Hardcoat

150

Memo

[8807] □1-Weld as per Dwg D3537 using Jig DT 8210□2-Remove any

weld that benetrated through Wearpadif necessary

Quality Control

QC10- Inspect visual per QSI004- ground welds

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W/O:	-		V	ORK ORDER CHA	NGES		· · · · · · · · · · · · · · · · · · ·			
DATE	STEP	PROC		· · · · · · · · · · · · · · · · · · ·		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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•							•			
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Part No	•	PAR #:	_ Fault Ca	tegory:	NCF	R: Yes	No DQ	٨:	_ Date: _	
	R	esolution:	_ Disposit	ion:	QA:	N/C CI	osed:		Date: _	
NCR:		W	ORK OR	DER NON-CONFOR	RMANCE	(NCF	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description					Approval Chief Eng	Approval QC Inspector
			Office Ling	Office Ling		Date				
								. ,		
	PAR #: Fault Category: NCR: Yes No DQA: I Resolution: Disposition: QA: N/C Closed: I WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC									
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W	ork O	rder ID	73	394	
We	dnesday,	August 31, 2	2011	3:04:09	PM
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Page 3

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Item ID:	D3537-1			Accept				se se	etup	Start			_
Revision ID: Item Name:	Wearpad		*							Stop			
Start Date: Required Date	8/31/2011 : 9/16/2011	Start Qty: 50.00 Req'd Qty: 50.00			Cust Item I Customer:	D:						1816 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	
Reference:	•		1103(01 01111 0111	. 1881									
Approvals:	Process Pla	ın:	Date:	Tooling:	Da	ate:	<u> </u>	R	un	Start			
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop			
Sequence ID/ Work Center I	D .	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	_
		QC5- Inspect part comple	eteness to step on W/O	0.00 S ulo	116		۷ (460	,				
QC		Memo		0.00	· •				/				

170

Quality Control

180

Quality Control

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo START TIME:

□OVEN TEMPERATURE:

DEINISH TIME:

QC3- Inspect Part Finish

0.00

Memo

0.00

60 BL 11-9-21.

W/O:			WO	RK ORDER CHANGI	:0				
DATE	STEP	PR	OCEDURE CHAI		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	-								
									·
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	n:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NC	R)			
		Description of NC		Corrective Action Section	on B	Vorific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	ion C	Chief Eng	QC Inspector
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Work Order ID 73394

Page 4

Item ID:

Wednesday, August 31, 2011 3:04:09 PM D3537-1

Accept

Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Wearpad

8/31/2011

Start Qty: 50.00

Required Date: 9/16/2011

Req'd Qty: 50.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____ Tooling: Date:

Run

Start

Stop

60 BR 11-9-21.



QC:

Date: _____

SPC (Y/N):

Set Up/

Run Hours

Date:_

Reject

Insp.

Sequence ID/ Work Center ID

190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

0.00

Tool ID

Tool # Plan Accept Code Qty

Reject Qty

Number

Stamp

200

Quality Control

Memo

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

0.00

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W/O:			WC	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	n:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCI	₹)			
DATE	0.755	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	Secti	on C	Chief Eng	QC Inspector
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								·	
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"Picklist Print

Wednesday, August 31, 2011 3:04:06 PM

Work Order ID: 73394

Parent Item: D3537-1

Parent Item Name: Wearpad

Start Date: 8/31/2011

Required Date: 9/16/2011

Page 1

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA	INITE APPRILATE LARGE	Purchased	No			100	sf	129.1000	0.106	5.578947	CoL	14-00-0	
										KB.	11-9-17)	

304/316 Sheet .063

<u>Location</u>	Loc Qty	Loc Code	
MAT020	116.5		
118578	116.5		
MAT021	12.6		
118217	12.6		118917





W/O:	: WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
									.:		
									,		
					Provide						
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date: _	·····		
Resolution:			Disposition: QA: N/C C				Closed: Date:				
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)					
		Description of NC	Corrective Action Section		tion B	Verifi	rification	Approval Chief Eng	Approval		
DATE	STEP	Section A	Initial Chief Eng				ion C		QC Inspector		
,											

DART AEROSPACE LTD	Work Order:	73394
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4,754	b	ľ	V 1B07	
3.500	+/-0.010	3.496	7		V	
1.965	+/-0.010	1.964	7		V	
2.795	+/-0.010	2.793	8		V	
3.625	+/-0.010	3.623	b		V	
0.220 x 0.380	+/-0.010	250x 384	4		V	
					1"	
				J.		. 3/8
				,		

Measured by:	(B	Audited by:		Prototype Approval:	N/A
Date:	11-9-17	Date:	ula13	Date:	N/A

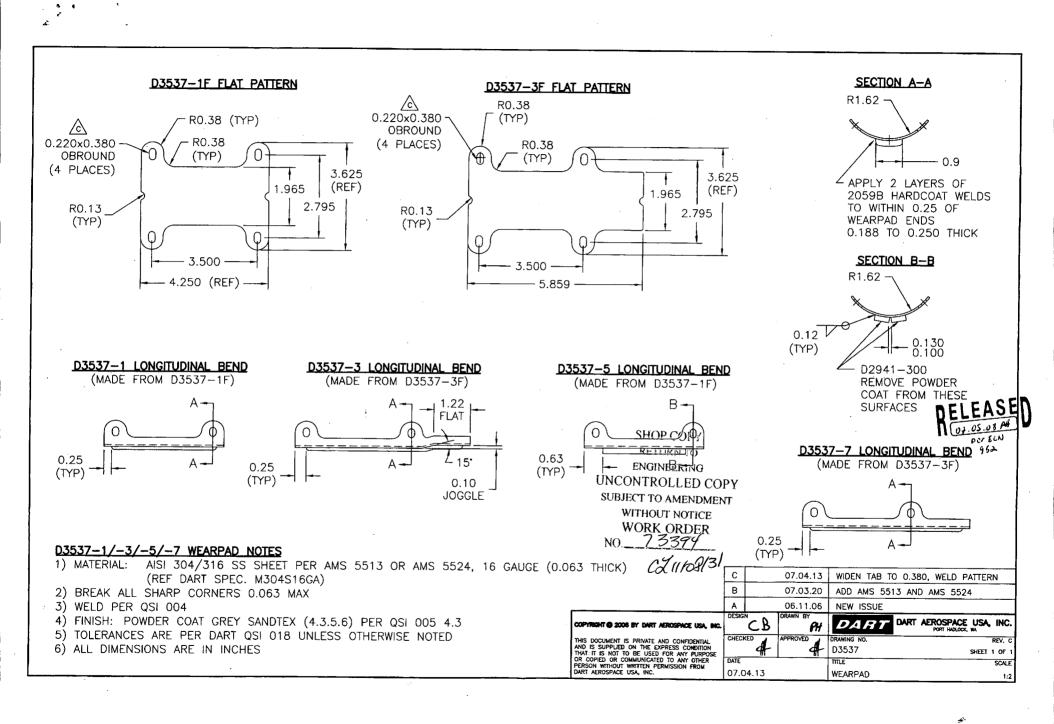
Rev	Date	Change	Revised by	Approved
Α	07.03.21	New Issue	KJ/JLM	
В	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	1
С	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	Gd
			77	

Dart Aerospace	Ltd
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W/O:		WORK ORDER C	* * * * * * * * * * * * * * * * * * *				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR: WORK ORDER NON-CONFORMANCE (N								
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC inspector
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W/O:			WO	ES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: PAR #:		PAR #:	Fault Cate	jory:	_ NCR: Yes	No DQ	A:	Date: _	
Resolution:			Disposition: QA: N/C Closed:			Closed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
		Description of NC	Corrective Action		Section B Veri		fication	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sect	Section C	Chief Eng	QC Inspector
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